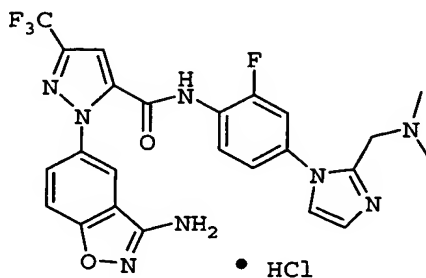


WHAT IS CLAIMED IS:

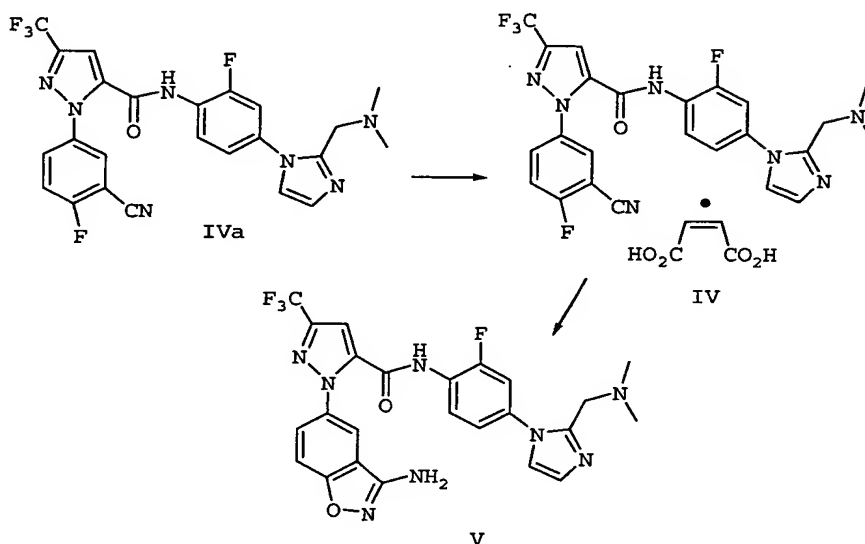
1. A process for making a compound of Formula I:



I

comprising:

- 5 (c) contacting a compound of Formula IVa with maleic acid to form a compound of Formula IV;



- 10 (d) converting a compound of Formula IV to a compound of Formula V; and,
- (e) forming a compound of Formula I.

- 15 2. A process according to Claim 1, wherein in (c), contacting with maleic acid is performed in the presence of a first solvent, ethyl acetate.

3. A process according to Claim 2, wherein in (c), a second solvent, 1-chlorobutane, is added to enhance precipitation.

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4. A process according to Claim 1, wherein (d) is performed by contacting a compound of Formula IV with HONHCOCH_3 in the presence of a base and a solvent.

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5. A process according to Claim 4, wherein the base is selected from K_2CO_3 , Na_2CO_3 , KHCO_3 , NaHCO_3 , KF , NaOH , and KOH .

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6. A process according to Claim 5, wherein the base is K_2CO_3 .

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7. A process according to Claim 4, wherein in (d), the solvent is selected from DMSO, DMAC, N-methylpyrrolidinone, and DMF.

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8. A process according to Claim 7, wherein in (d), the solvent is DMF, comprising: 0.5 to 50% by volume of water.

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9. A process according to Claim 7, wherein in (d), the solvent is DMF, comprising: 10, 11, 12, 13, 14, to 15% by volume of water.

10. A process according to Claim 7, wherein in (d),
the solvent is DMF, comprising: 15% by volume of water.

5

11. A process according to Claim 1, wherein (e) is
performed by contacting a compound of Formula V with HCl
in a solvent selected from methanol, acetonitrile,
10 isopropyl alcohol, ethanol, propanol, acetone, methyl
isobutyl ketone (MIBK), 2-butanone, and water.

12. A process according to Claim 11, wherein (e) is
15 performed by contacting a compound of Formula V with HCl
in ethanol.

13. A process according to Claim 1, wherein the
20 compound of Formula I is a mono-HCl salt.

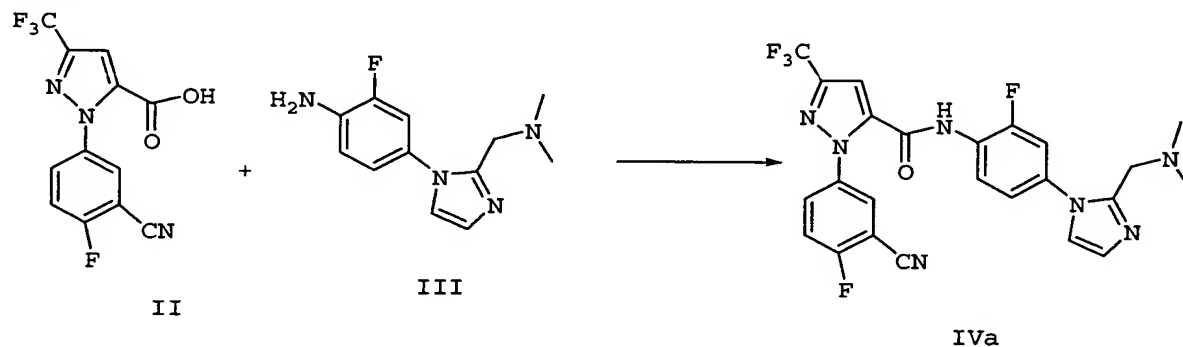
14. A process according to Claim 1, wherein the
compound of Formula I is crystalline.

25

15. A process according to Claim 1, wherein the
compound of Formula I is a solvate selected from ethanol,
propanol, isopropanol, acetone, MIBK, 2-butanone, and
30 water.

16. A process according to Claim 15, wherein the compound of Formula I is an ethanol solvate.

5 17. A process according to Claim 1, wherein the compound of Formula IVa is prepared by the process, comprising:



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(b) coupling compounds of Formulas II and III to form a compound of Formula IVa.

15 18. A process according to Claim 17, wherein the compound of Formula IVa is used without purification in (c).

20 19. A process according to Claim 17, wherein (b) is performed by contacting a compound of Formula II with an acid activator, in a solvent and a first base, followed by contacting the resulting solution with a compound of Formula III.

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20. A process according to Claim 19, wherein (b) is performed by contacting a compound of Formula II with oxalyl chloride in acetonitrile and pyridine, followed by contacting the resulting solution with a compound of

5 Formula III.

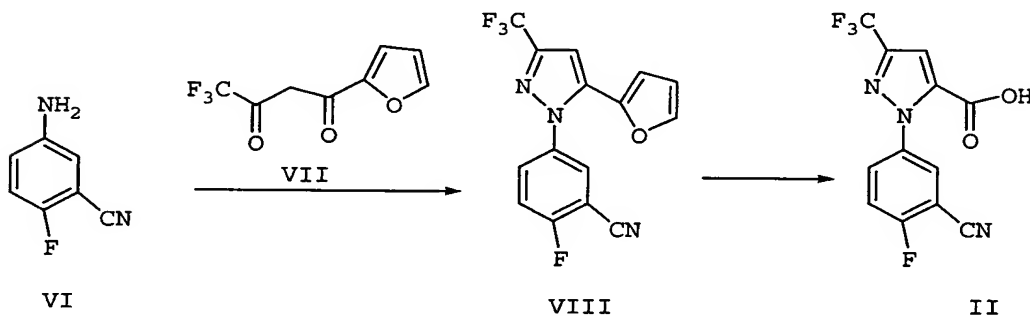
21. A process according to Claim 20, wherein after a compound of Formula II has been contacted with a

10 compound of Formula III, a second base is added to the reaction solution.

22. A process according to Claim 21, wherein the

15 second base is diisopropylethylamine.

23. A process for making a compound of Formula II:



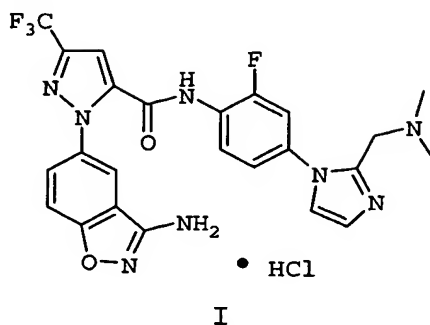
20 comprising:

(a) contacting a compound of Formula VI with a compound of Formula VII to form a compound of Formula VIII; and,

(a₁) converting a compound of Formula VIII to a

25 compound of Formula II.

24. A compound of Formula I:



wherein I is a mono-HCl salt.

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25. A compound according to Claim 24, wherein the compound of Formula I is crystalline.

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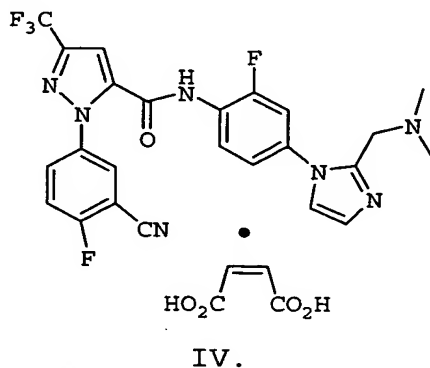
26. A compound according to Claim 24, wherein the compound of Formula I is a solvate selected from ethanol, propanol, isopropanol, acetone, MIBK, 2-butanone, and water.

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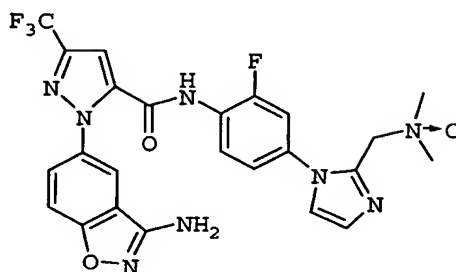
27. A compound according to Claim 26, wherein the compound of Formula I is an ethanol solvate.

20

28. A compound of Formula IV:



29. A compound of Formula Va:



Va

or a pharmaceutically acceptable salt form thereof.

30. A pharmaceutical composition, comprising: a pharmaceutically acceptable carrier and a therapeutically effective amount of a compound according to Claim 24 or a pharmaceutically acceptable salt thereof.

31. A method for treating a thromboembolic disorder, comprising: administering to a patient in need thereof a therapeutically effective amount of a compound of Claim 24 or a pharmaceutically acceptable salt thereof.